

Work Order ID 72839

Wednesday, August 17, 2011 10:14:35 AM



Page 1

Item ID: D2792-130	Accept		Setup Start	
Revision ID:			Stop	
Item Name: EXTRUSION				
Start Date: 8/16/2011	Start Qty: 50.00		Cust Item ID:	
Required Date: 8/26/2011	Req'd Qty: 50.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/08/17</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2792	Rev A1								

100 PURCHASING 0.00
 Purchasing Memo 0.00
Purchasing Issue P/O: 14737 ☐ a) Extrude as per Dwg D2792 ☐ b) Material: 6061-T6 (QQ-A-200/8) ☐ c) Tool: MS-19248 ☐ d) Material certification is required. ☐ e) 130 is equal to 130.0"

CL 11/08/25 (50)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 Packaging Memo 0.00
Packaging Ensure material certification and pull test results attached

11/15/10 (50)

120 QC6- Inspect dimensions to drawing 0.00
 QC Memo 0.00
Quality Control Check pull test Report to Dwg D2792 for compliance

Sumal/21
Spot check at (40)
Sumal/21

COUNT
(862)
BA D310

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				8/95			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72839

Wednesday, August 17, 2011 10:14:35 AM



Page 2

Item ID: D2792-130

Accept



Setup Start



Revision ID:

Stop



Item Name: EXTRUSION

Start Date: 8/16/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

id pcs must be brought to QC
for spot checkin',
5/19/11

Tap Bites

9/11/20

62

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

[Handwritten signature]

11/9/21
mk
11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 10:19:29 AM

Page 1

Work Order ID: 72839



Parent Item: D2792-130



Parent Item Name: EXTRUSION



Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A ☐ 98.11.09 ☐ New Issue ☐ KS ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130P  EXTRUSION		Purchased	No			100	Each	0.0000	1 	50		8/16/11 (50)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

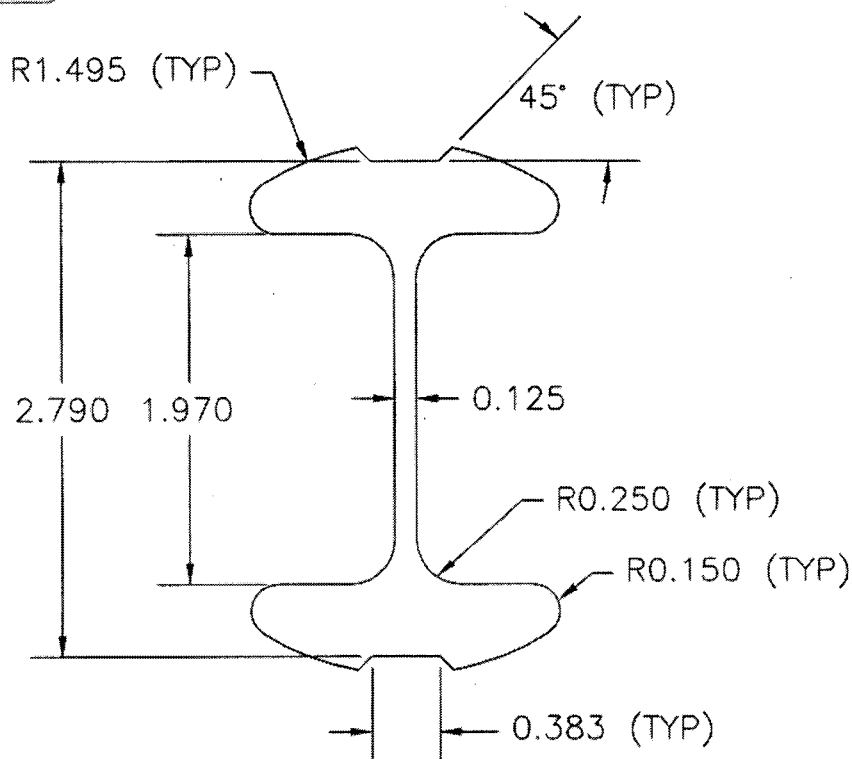
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>RAH</i>	DRAWN BY <i>RAH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>GA</i>	DRAWING NO. D2792	REV. A SHEET 1 OF 1
DATE 98.08.13		TITLE EXTRUSION	SCALE 1:1
A	98.08.13	NEW ISSUE	
A1	01.04.17	ADD NOTE *7 <i>CP</i>	

RELEASED
98.08.25 DS



GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2. MANUFACTURED USING CARADON INDALEX DIE # MS-19248
3. BREAK ALL SHARP CORNERS 0.010 MAX.
4. NO ID TOOLING MARKS.
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
6. ALL DIMENSIONS ARE IN INCHES.
7. PART NUMBER IS D2792-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2792-145 IS 145" LONG)



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14737

Purchase Order Date 8/25/2011

PO Print Date 8/25/2011

Page Number 1 of 1

Order From :

VC-SAP001

SAPA CANADA INC
LOCKBOX B9427
PO BOX 9100
POSTAL STATION F
TORONTO, ONTARIO M4Y 3A5
CANADA

Contact Name

Vendor Phone 800 563 5120

Vendor Fax 800 563 8310

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2792-130P	EXTRUSION	9/14/2011 Yes	50.00 Each	Yours ppd	\$42.4583	\$2,122.92

Special Inst: AS PER DWG D2792 REV. A
B72839

PO Total:

\$2,122.92

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PO Instructions:

PLEASE ADVISE DELIVERY

Change Nbr: 1

Change Date: 8/25/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Sapa Canada, Inc.
Adresse Postale 325, rue Avro
Pointe-Claire, Québec H9R 5W3
Téléphone: (514) 697-5120
Télécopieur: (514) 694-8310

sapa:

EXPÉDIÉ / SHIP TO

INDICATIONS SPÉCIALES
SPECIAL INSTRUCTIONS

P/S#: 791599
NOTRE NUMÉRO DE COMM.
OUR ORDER NO.

~~1081977~~

CERTIFIÉ
ISO 9001:2008

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONT

K6A1K7

[illegible][illegible]

325 rue Avro
Pointe-Claire, QC, Canada H9R 5W3
Téléphone (514) 697-5120
Fac-simile (514) 694-8310

sapa:

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**

Adresse / Address : **1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7**

Commande Sapa / Sapa order # : **1081977**

Bon de commande / Purchase order # : **14737**

Matrice / Die # : **MS 19248**

Description : **"I" SUPPORT COMPONENT**

Alliage & trempage / Alloy & temper : **6061 T6**

Customer Part # : **D2792**

Contrôle / Control # : **51537-1**

Coulée / Cast # : **52012**

	Min.requis Min.required	Résultat actuel Actual Results
Tension ultime Ultimate stress (psi)	38 000	42,973
Contrainte élastique Yield stress (psi)	35 000	35,470
% élongation dans 2" % elongation in 2"	8	14
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	88 @ 100	94

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,68 - 0,72	0,15 - 0,27	0,08 - 0,12	0,20 - 0,24	0,48 - 0,52	0,03 Max	0,05 Max	0,03 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	---	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221-08 excepté pour la section 8.2 (nombre de spécimen) .

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221-08 except for section 8.2 (number of specimen) .

Sincèrement vôtre,
Yours truly,

date : **2011-09-07**



Gilles Pelletier
Technicien de la qualité
Quality technician